

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019259**Date Inspected:** 30-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

Notification no: 007554.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) SEG3014N-003.
- 2) SEG3015A-011.

(UT of the Jacking area of the above welds not included in this notification).

This QA Inspector observed the following work in progress:

OBG Seg 14W:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ZPMC personnel doing heat straightening of weld jt no: SEG3020AX-004 [Bottom Panel (BP) 3087A to Side Panel (SP) 3131A, complete joint penetration (CJP) weld]. Heat straightening was done as per heat straightening report (HSR): 9913 Rev-0. See attached photo for further details. ZPMC QC was identified as Qiu Wen.

OBG Seg 13AW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3013F-003 [Floor Beam (FB) to BP, CJP weld; at Panel Point (PP) 119+1500]. The welder is identified as 201215 and was observed welding in the 2G position. ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS): B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3013K-005 [FB to Longitudinal Diaphragm (LD), fillet weld; at PP119-1500]. The welder is identified as 047866 and was observed welding in the 3F position. ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-ESAB.

The FCAW process on weld joint no: SEG3013Q-031 [FB I-rib stiffeners to Sub Assembly (SA) Plate, CJP weld]. The welder is identified as 068852 and was observed welding in the 2G position. ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB. As per drawing, this weld is to be welded as fillet weld. However, due to excess root gap (7mm), it is welded as CJP.

The FCAW process on weld joint no: SEG3013V-170 (SA to FB, fillet weld; at PP119-1500). The welder is identified as 045175 and was observed welding in the 3F position. ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
